

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019888**Date Inspected:** 29-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xiang Feng Hong.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG 13BE

PCMK: SP3071-001

Weld No: 223,225,239,235

Welders: 058087

WPS-B-T-2231-ESAB

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xiang Feng Hong.

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA Inspector.

Component; OBG 13BE (see photo below)

PCMK: AH3151A

Weld No: 004,005

Welders: 050977

WPS-B-T-2213-TC-U4b

Heat straightening of PCMK, 20TR-033 under approved Heat Straightening procedure, HSR1 (B)-362. The in process temperature was approximately 250°C using a temperature indicating marker (Tempstik). The ZPMC QC was identified as Xiang Feng Hong. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 8

This QA Inspector observed the following work in progress for Bay 8.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Liu Fa Won.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path, Bottom Plate

PCMK: BK004A2-057

Weld No: fit up

Welder: 047470

WPS-B-T-2112

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in Bike Path, BK004A-059 and 062 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Sheng Qing Quan.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG 13AE

PCMK: SEG3007AT

Weld No: 056

Welder: 215553

Weld Repair: B-WR19219

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WPS-345-SMAW-2G(2F)-FCM-Repair-1

Component; OBG 13AE

PCMK: SEG3007AT

Weld No: 069

Welder: 216086

Weld Repair: B-WR19220

WPS-345-SMAW-2G(2F)-FCM-Repair-1

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Liu Dao Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; OBG Hand Rail

PCMK: BKR-NS-10 & 36

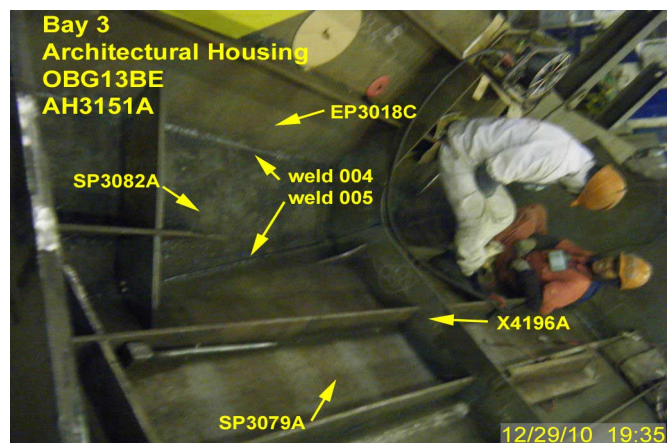
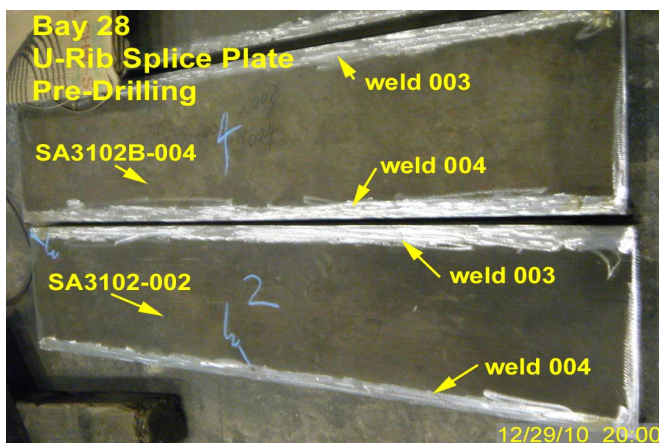
Weld No:

Welders: 058087

WPS-B-T-2231-ESAB

This Caltrans QA Inspector observed at random intervals ZPMC performing contour grinding of welds located on u-rib splice plates then match drilling of bolt holes on piece numbers SA3102B, SA3117B, and SA3185D. ZPMC QC is identified as Liu Dao Feng. (see photo below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer